

Work Order ID 64593

Thursday, December 09, 2010 8:19:14 AM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revisor ID:

Item Name: Rib Assembly

Stop



Start Date: 12/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-12-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c/sink hole as per dwg

4- remove identification markings

5- deburr

SAD 10-12-23

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: *111585*

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

PL 11-01-14

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____




Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




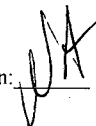
NOTE: Date & initial all entries

Thursday, December 09, 2010 8:19:14 AM

Page 2

Item ID:	D3852-042	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly				Stop	
Start Date:	12/9/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	12/16/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		Sublet 4		10			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sublet 4		+2 -012			
150  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00		SAD 11-01-14		2			

W/O:		WORK ORDER CHANGES					
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Work Order ID 64593

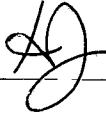
Page 3

Thursday, December 09, 2010 8:19:14 AM

Item ID: D3852-042 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly Stop 
Start Date: 12/9/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 12/16/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/01/17 

A. Woolley

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, December 09, 2010 8:19:18 AM

Page 1

Work Order ID: 64593

Parent Item: D3852-042

Parent Item Name: Rib Assembl.y




Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3  Basket Hoop		Manufactured	No			100	Each	4.3281	0.18	0.378947			

SAD 10-12-23

Location	Loc Qty	Loc Code
WA	4.328071053	
55697	2.1053E-05	
59266	0.0418	
60270	0.00265	
61193	0.0416	
63063	4.242	

D3759-1

Bushing

Manufactured No 100 Each 35.0000

Location	Loc Qty	Loc Code
WA	35	
54072	9	
63876	26	

0.3790

2
Cpl 11.01.14

B64421 → (2)

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8

7

6

5

4

3

2

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUS. JING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs EACH
- 8) WELDING: PER QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64593
B810-12-9

RELEASE
08/11/07 MB

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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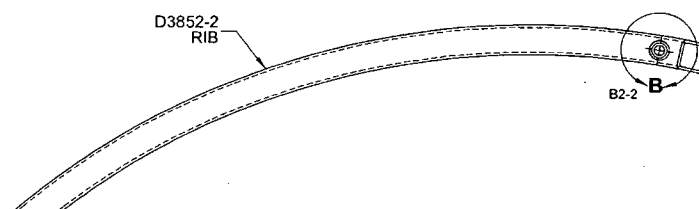
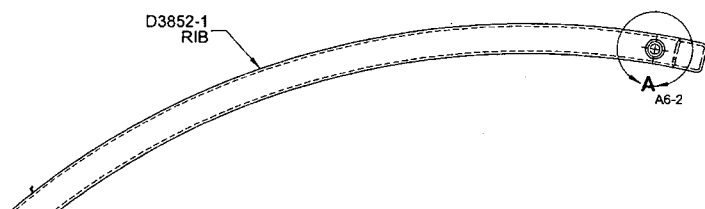
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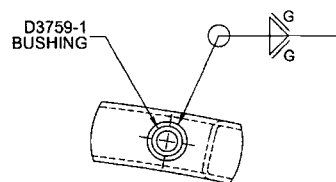
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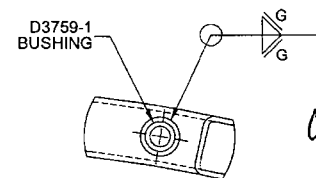


D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2



DETAIL B
SCALE 2X C2-2

W1064593

RELEASED
08/11/14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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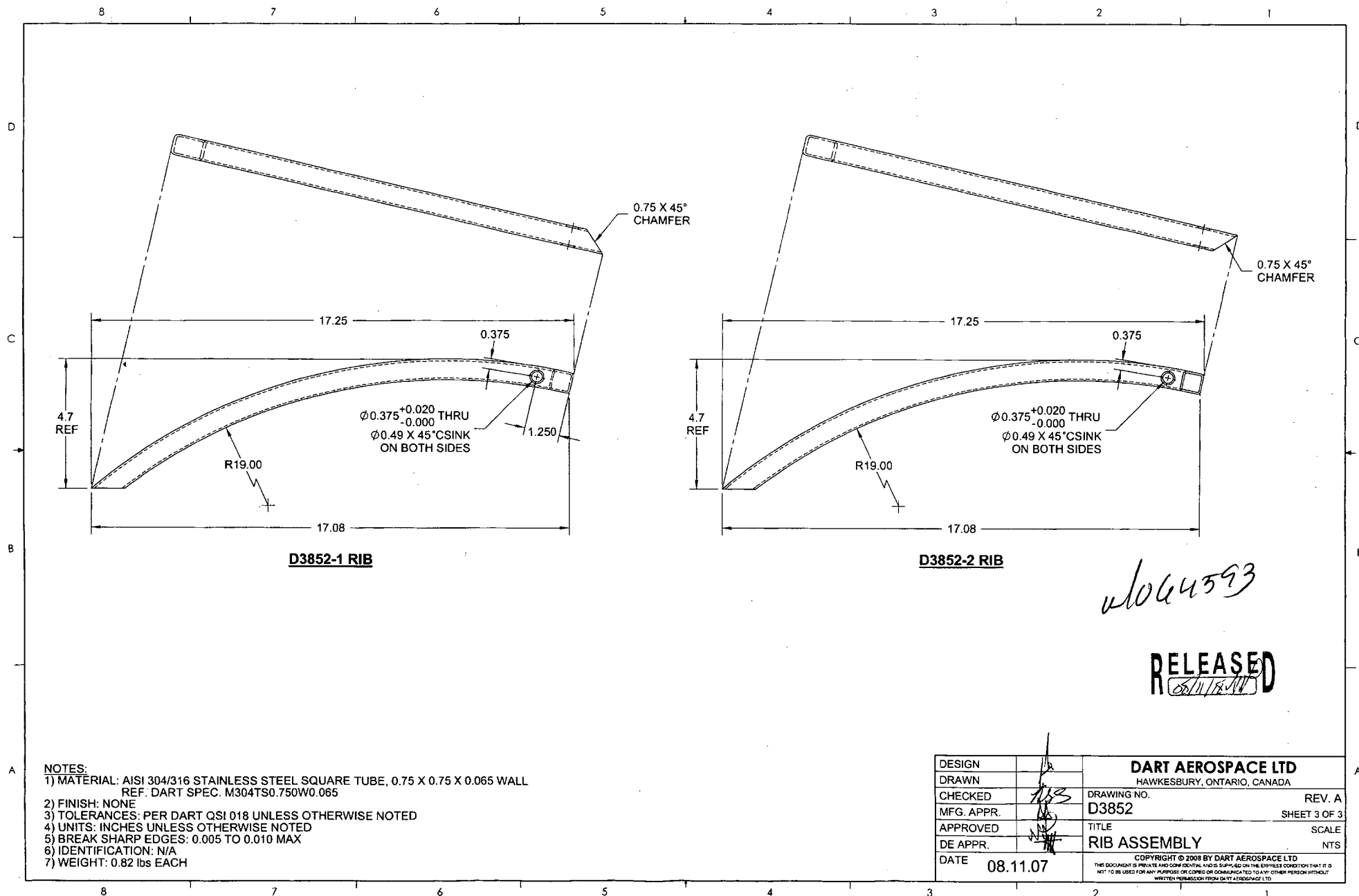
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